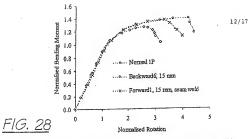
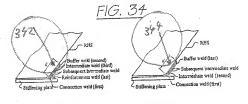
Inventor: Teh, Lip Serial No.: 10/552,180 Filing Date: October 5, 2005 Atty. Docket: 2373/111 Annotated Marked-up Drawing



Comparison between 150×50×4 specimens with and without seam weld



(a) Backward bead deposit sequence

(b) Forward bead deposit sequence